

Work Order ID 148101

June 24, 2016 11:36:57 AM

148101

Ship July 5
or sooner.

Page 1

Item ID: D206-802-133

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: 5 Door Opener - Composite Baggage Door

Stop *NS2*

Start Date: 6/24/2016 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 7/5/2016 Req'd Qty: 1.00 *1*

Customer:

Reference:

Approvals: Process Plan: SA Date: 6/24/16 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start *NR1*
Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
IIN-D407-802-3	A

100	Document Control	0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile and create labels per PPP D206-802-133 CHG002								

SA 6/24/16

105	Pick Kit	0.00							
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105									
Packaging	Memo	0.00							
Packaging									

JUN 27 2016

DAS 27
9-89

110	QC4- 100% Inspect kits for completeness	0.00							
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110									
QC	Memo	0.00							
Quality Control									

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9-89

JUL 05 2016

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
							Completed By		
							Lead hand / Supervisor Approval Verification		
							QC / QA Coordinator Approval		
Root Cause		FAULT CATEGORY							
Environment ☐	☐ No Re-verification	☐ Pressure/Forced	☐ Temperature/Cure	☐ Power Loss/Surge	☐ Positioned Wrong				
Design ☐	☐ Operator	☐ Bending	☐ Set-up	☐ Folio/Program	☐ Outside Dimensions				
Doc/Data ☐	☐ Offset/Setup	☐ Centre Not Concentric	☐ BOM/Route	☐ Grain	☐ Over/Under tolerance				
Equip/Tooling ☐	☐ Supplier	☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Part Incorrect				
Handling/Pre ☐	☐ Training	☐ Crimp/Kink/Ripple/Wave	☐ Inspection Incomplete/Unqualified	☐ Wrong Stock Pulled	☐ Part Lost/Missing				
Material ☐	☐ Use for Testing	☐ Cuffs	☐ Contamination	☐ Out of Sequence	☐ Part Moved				
Internal Transport ☐	☐ Poor Information	☐ Crushing	☐ Countersink	☐ Off-set	☐ Drawing				
Tribal Knowledge ☐	☐ Rushing	☐ Heat Treat	☐ Cut Too Short	☐ Misabeled	☐ Finish				
LOA ☐	☐ Product Improvement	☐ Wave/Twist in Tube	☐ Instructions Incomplete/Unclear	☐ Fit/Function	☐ Misread				
Substation ☐	☐ Process Improvement	☐ Marks/Chatter	☐ Drill Holes	☐ Misaligned/off center	☐ Turning Sequence				
Past Expiry Date ☐	☐ Manufacturing Process	OTHER : _____							
Misidentified ☐	☐ Past Due								

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Item ID: D206-802-133

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

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Required Date: 7/5/2016 Req'd Qty: 1.00 ***1***

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***
Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120		0.00							
120	Packaging					/	DAS 28 9-89	DAS 27 9-89	JUL 05 2016
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPPDD206-802-133 Location: _____ PPP rev: _____								
130		0.00							
130	QC21- Final Inspection - Work Order Release								
QC	Memo	0.00					DAS 21 9-89		JUL 05 2016
Quality Control									

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DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Picklist Print

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Work Order ID: 148101

148101

Parent Item: D206-802-133

D206-802-133

Parent Item Name: 5 Door Opener - Composite Baggage Door

Start Date: 6/24/2016

Required Date: 7/5/2016

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 10.12.03 as per dwg rev.A DD verf:EC
12.07.30 AS PER ECN12-624 DD verf:EC
IPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D206-802-029		Manufactured	No			105	Each	1.0000	1	1			
D206-802-029									**				
Crew Door Opener LH													
	DAS 28 9-89				<u>Location</u> FG021 129652			<u>Loc Qty</u> 1 1		<u>Loc Code</u>		DAS 6 9-89	DAS 27 9-89
D206-802-030		Manufactured	No			105	Each	1.0000	1	1			
D206-802-030									**				
Crew Door Opener RH													
	DAS 28 9-89				<u>Location</u> FG021 129875			<u>Loc Qty</u> 1 1		<u>Loc Code</u>		DAS 6 9-89	DAS 27 9-89
D206-802-031		Manufactured	No			105	Each	0.0000	1	1			
D206-802-031									**				
Passenger Door Opener LH													
D206-802-032		Manufactured	No			105	Each	0.0000	1	1			
D206-802-032									**				
Passenger Door Opener RH													
D407-802-019		Manufactured	No			105	Each	2.0000	1	1			
D407-802-019									**				
Baggage Door Opener Composite Door													
	DAS 28 9-89				<u>Location</u> FG021 125935 126793			<u>Loc Qty</u> 2 1 1		<u>Loc Code</u>		DAS 6 9-89	DAS 27 9-89

JUN 27 2016

REFERENCE ONLY

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5.3 D206-802-033 Baggage Door Opener Kit, Metal

Qty -033	Part Number	Description
☒	D206-802-033	BAGGAGE DOOR OPENER KIT, METAL
1	D3552-19	DOOR PROP
1	D4109-043	DOUBLER ASSEMBLY
1	D4113-041	DOUBLER ASSEMBLY, BAGGAGE DOOR
4	80-004-2-6	INSERT
8	CR3213-4-2	RIVET
4	MS27039C1-06	SCREW
4	NAS1149C0363R	WASHER

5.4 D407-802-019 Baggage Door Opener Kit, Composite

Qty -019	Part Number	Description
☒	D407-802-019	BAGGAGE DOOR OPENER KIT, COMPOSITE
1	D3552-19	DOOR PROP
1	D4109-041	DOUBLER ASSEMBLY, BULKHEAD
1	D4109-043	DOUBLER ASSEMBLY
3	80-004-2-6	INSERT
4	MS27039C1-05	SCREW
3	MS27039C1-06	SCREW
7	NAS1149C0363R	WASHER
4	NAS1836-3-08M	INSERT

5.5 D206-802-131/-133/-135 Combination Kits.

Qty -131	Qty -133	Qty -135	Part Number	Description
☒	☒	☒	D206-802-131	5 DOOR OPENER KIT (METAL BAGGAGE DOOR)
☒	☒	☒	D206-802-133	5 DOOR OPENER KIT (COMPOSITE BAGGAGE DOOR)
☒	☒	☒	D206-802-135	4 DOOR OPENER KIT
1	1	1	D206-802-029	CREW DOOR OPENER KIT, LH
1	1	1	D206-802-030	CREW DOOR OPENER KIT, RH
1	1	1	D206-802-031	PASSENGER DOOR OPENER KIT, LH
1	1	1	D206-802-032	PASSENGER DOOR OPENER KIT, RH
1			D206-802-033	BAGGAGE DOOR OPENER KIT, METAL
	1		D407-802-019	BAGGAGE DOOR OPENER KIT, COMPOSITE

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Revision: **A**
Date: 10.10.13